

# Work Order ID 60423

Wednesday, July 07, 2010 1:16:33 PM



Page 1

Item ID: D3034-1

Revision ID:

Item Name: Bearpaw

Start Date: 7/7/2010 Start Qty: 8.00

Required Date: 7/21/2010 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: *10-7-7*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3034

Rev A1

120



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3034-1\_BLANK

*B 10-7-19*

*8*

130



HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA148 Rev: *AA* & Dwg D3034 Rev: *A1*  
2-Deburr per dwg D3034

*only 10/07/28*

*8*

*8*

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*only 10/07/28*

*8*

*8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

L.A 10/07/28

8

0

151



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

PDP  
60418

B 10/1/29 8

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/29 H

PL 10-7-29  
8

W/O:		WORK ORDER CHANGES						
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# Picklist Print

Wednesday, July 07, 2010 1:16:33 PM

Page 1

Work Order ID: 60423

Parent Item: D3034-1

Parent Item Name: Bearpaw



Start Date: 7/7/2010

Start Qty: 8.00

Required Date: 7/21/2010

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	227.7473	4.16	33.28	40.		

UHMW 1" Black



Location

MAT

113903

114624

Loc Qty

227.7473

86.9473

140.8

Loc Code

114624

210-7-19

8

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

<b>D3034DART AEROSPACE LTD</b>		<b>Work Order:</b> 60423
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3034-1
<b>Inspection Dwg:</b> D3034	<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 11.75	+/-0.030	11.750	—		M-tape	ML-2
B 3.40	+/-0.030	3.400	—		Vern	ML-7
C 19.00	+/-0.030	19.000	—		M-tape	ML-2
D 0.375	+/-0.010	0.385	—		Vern	ML-7
E 0.950	+0.030/-0.010	0.965	—		Vern	ML-7
F 0.06 x 45°	+0.030/-0.010	0.075 x 45°	—		Vern	ML-7
G 0.25 x 45°	+/-0.030	0.255 x 45°	—		"	"
H R0.25	+/-0.030	R.25	—		R-gage	
I 0.630	+/-0.030	0.635	—		Vern	ML-7
J 0.250	+/-0.010	0.245	—		Vern	"
K 4.50	+/-0.030	4.50	—		"	"
L 0.20	+/-0.030	0.200	—		"	"
M Ø0.260	+0.005/-0.000	0.260	—		"	"
N Ø0.93	+/-0.030	0.925	—		"	"
O 0.30	+0.030/-0.000	0.305	—		"	"
P 28.25	+/-0.030	28.250	—		M-tape	ML-2
Q 0.37	+/-0.030	0.385	—		Vern	ML-7
R 4.750	+/-0.030	4.750	—		M-tape	ML-2
S 9.750	+/-0.010	9.750	—		"	"
T 11.000	+/-0.010	11.000	—		"	"
U 8.66	+/-0.030	8.660	—		"	"
V 5.000	+/-0.010	5.000	—		Vern	ML-7

<b>Measured by:</b> <i>Amf</i>	<b>Audited by:</b> <i>B.A</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/07/27	<b>Date:</b> 10/07/28	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.09.22	New Issue P/O D119-647-011	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

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**DART**

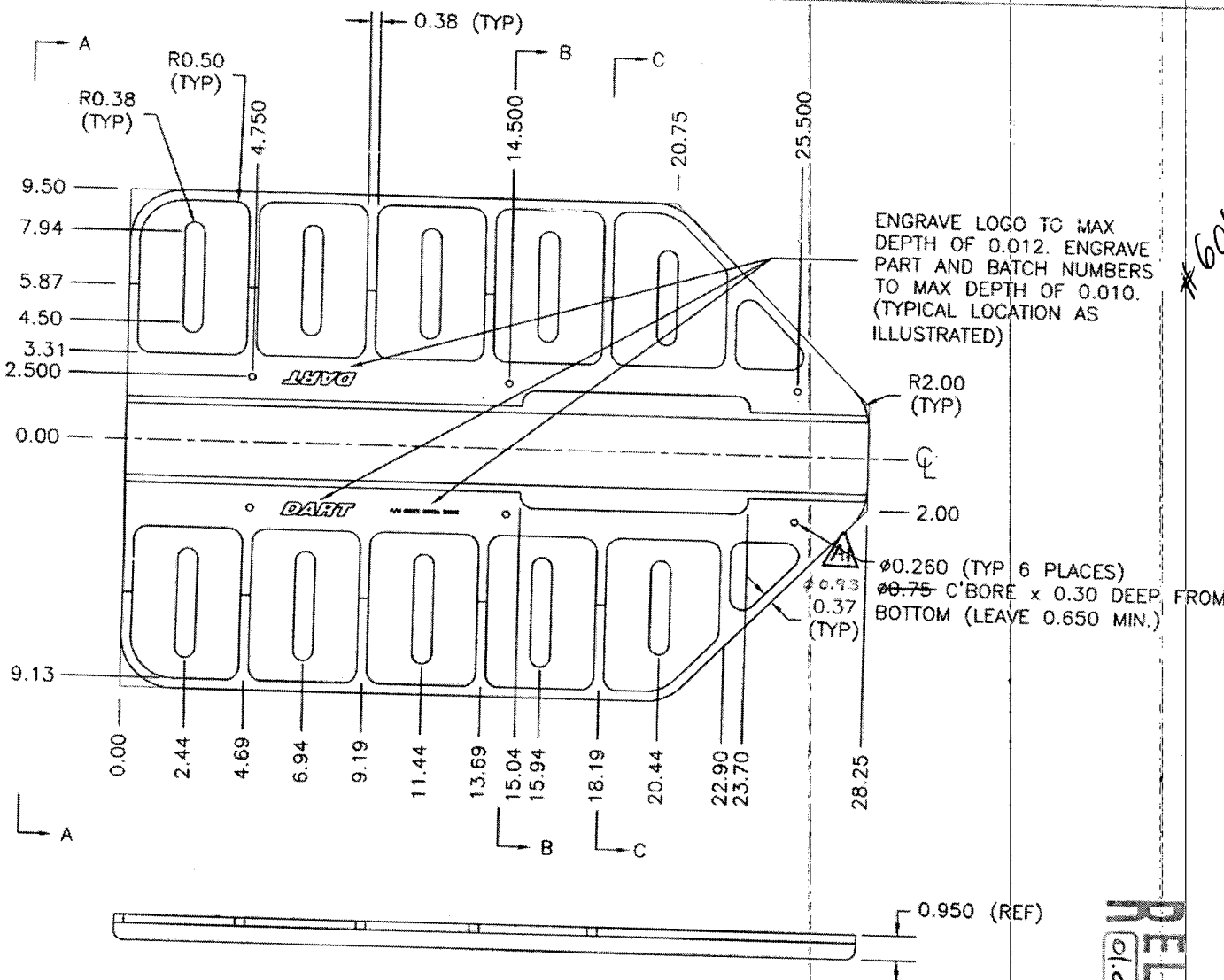


DESIGN		DRAWN BY		DART AEROSPACE USA, INC.	
CHECKED	DATE	APPROVED	DRAWING NO.	PORT HADLOCK, WA	
12	01.06.21	12	D3034	REV. A	
			TITLE	SHEET 1 OF 2	
			BEARPAW	SCALE	
			NEW ISSUE	1:5	

\*60423

RELEASED  
01.06.26

A1 03.01.06 0.93 WAS 0.75



D3034-1  
BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)  
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

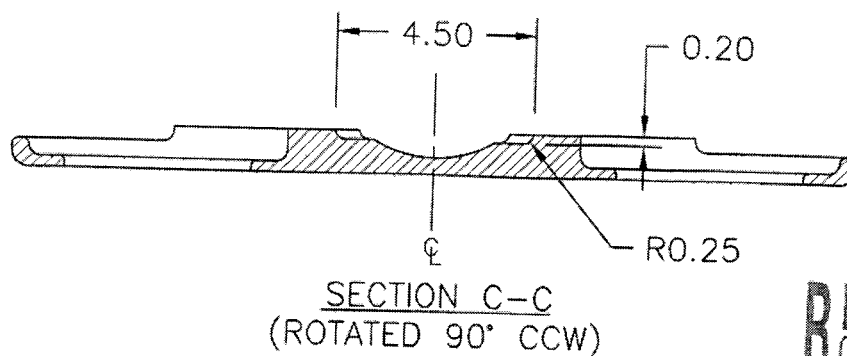
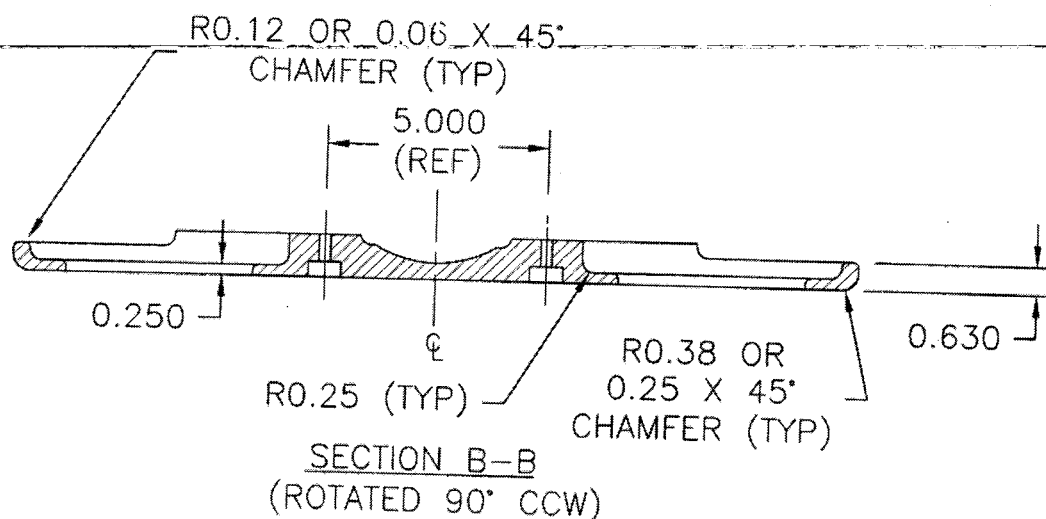
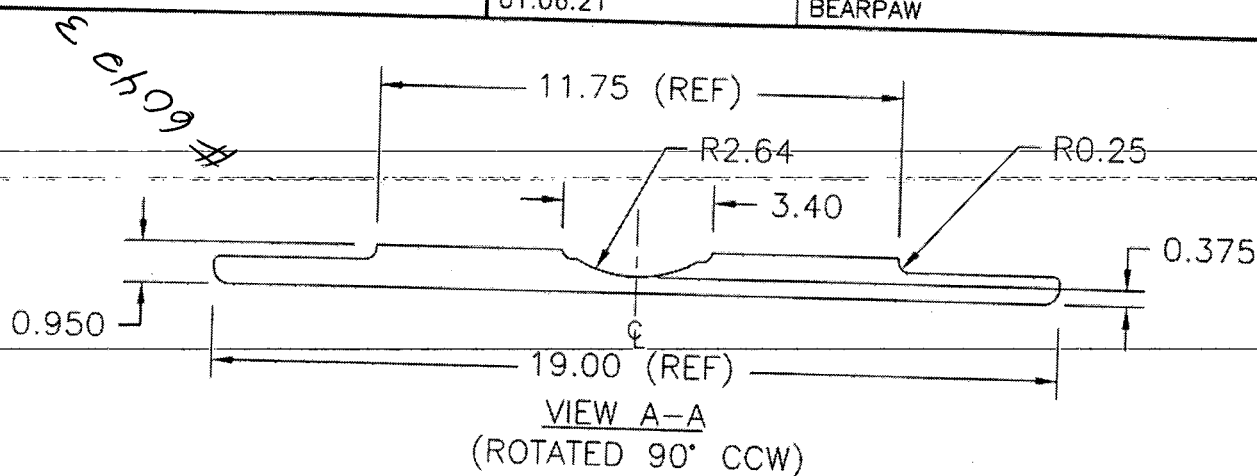
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DESIGN #	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3034	REV. A
DATE 01.06.21		TITLE BEARPAW	SHEET 2 OF 2
			SCALE 1:4



RELEASED  
9.6.26 #

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